



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW109-3130-82-105-5
Job Sheet 188818



Part No: RBW109-3130-82-105-5

Job Qty: 4 pcs

Part Name: Coupling Nut



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/16/19

Job Tracking No:

Due Date: 2/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW109-3130-82-105 Rev.2 IPP Rev. A 18.12.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Conventional Lathe - 1	4 pcs	2/8/19	2/8/19	0.00	2.00	Conventional Lathe - 1		
							Conventional Lathe - 2		
110	QC 2	4 pcs	2/8/19	2/8/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



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Container No: S148553



Part: RBW109-3130-82-105-5

Job No: 188818

Serial No/Batch: S148553

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 01/28/19

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

120	QC 8	4 pcs	2/8/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	<i>ank 19/10/29</i>
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 38	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
130	Packaging 3-1 - Stock - B4B	4 pcs	2/8/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	<i>EL</i>
140	QC 21 - SA	4 pcs	2/8/19	0.00 0.00	QC 21 - SA - 21	<i>DAS</i>
	Part Op 100 - 1-Machine as per DWG. 2-Deburr					<i>21</i>
	Descriptions: 130 - .					<i>9-88</i>
<i>JAN 29 2019</i>						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
90977A165	Coupling Nut	4 Ea (1 ea)	100-Conventional Lathe - 1	STH/ST		
<i>MT-4140 BT - R.O. 625</i>				<i>SC07115</i>	CABE	
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Conventional Lathe - 1	90977A165	4	10	0		
Part Specifications						
Specifications could not be found.						

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																															
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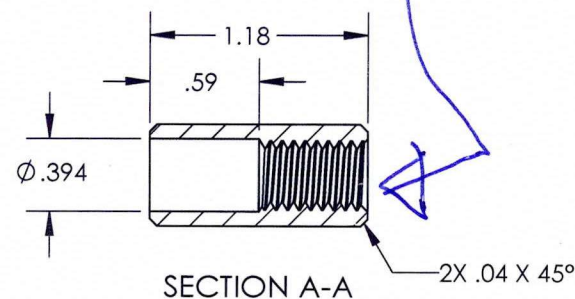
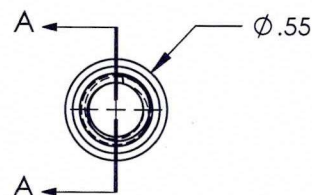
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



3/8-16UNC

SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. *188818 mcs*
1901-16



Ø 5/8 4140

(-5)

COUPLING NUT

DART AEROSPACE	
TITLE TAIL ROTOR BUSHING INSTALLATION TOOL	
DWG NO. RBW109-3130-82-105-5	REV 2
MATL STEEL GRD 5	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weel</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH SEE -1 WEELDMENT
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AW109, AW119
SCALE 1:1	DATE 8/26/2010
SHEET 4 OF 8	